

Date: Tuesday, 27/05/2008 9:07:09 AM
User: Linda Lacelle

Process Sheet

Spent w/o
SB 08/06/09

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR ARM
Job Number : 39504 -1
Estimate Number : 10505
P.O. Number :
This Issue : 27/05/2008 S.O. No. :
Prsht Rev. : NC Part Number : D2010103
First Issue : / / Type : SMALL / MED FAB Drawing Number : D2010 PRELIM
Previous Run : 38795 Drawing Revision : PRELIM 08.05.30
Written By : Due Date : 03/06/2008 Qty: 14 Um: 20 Each
Checked & Approved By :
Comment : Est : F 02.08.21 Re-format; Added D2057 KJ/RF
Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W049 304 RD Tube .500 x .049W



Comment: Qty.: 1.5750 f(s)/Unit Total : 31.5000 f(s)
Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall
(M304TR0500W049) Batch No: M107518 (14) SB 03/06/02

08.05.30 M108215

(6)

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC
Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727
Identify as D2010-103

SB 08/06/02

(20)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Bend as per Dwg D2010 using bending Jig D2010-103T2
2- Deburr ends

SB 08/06/02 (20)

4.0 D2057



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
Plug
Pick:

Qty Part Number Description Batch
1 D2057 Plug

D2057 39661

FF 08-06-09 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/05/2008 9:07:09 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39504

Part Number: D2010103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-flare before installing plug as per dwg D2010

2-Install D2057 plug as per Dwg D2010

FF 08-06-09 14

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 080609 (14)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20 OF
320
9:50

M-1 08/06/10

(14X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/06/10 (14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5/228
08/06/10 (14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



12 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

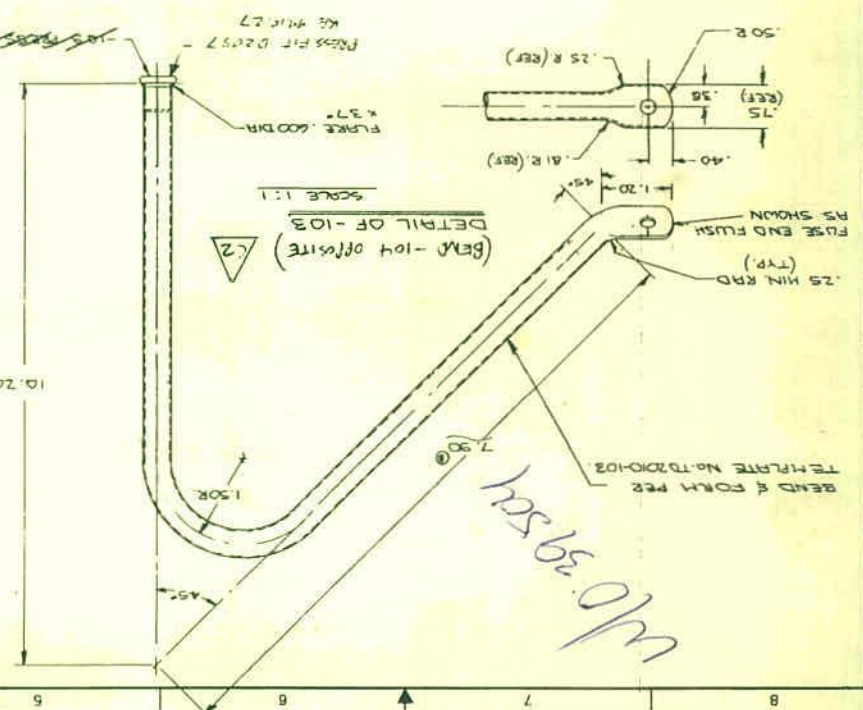
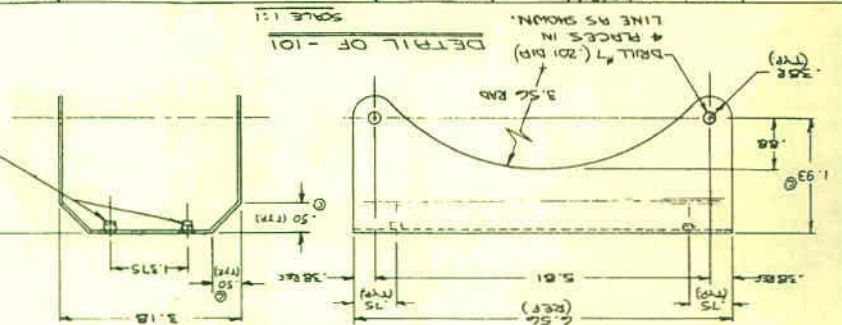
08-50-90
640-0

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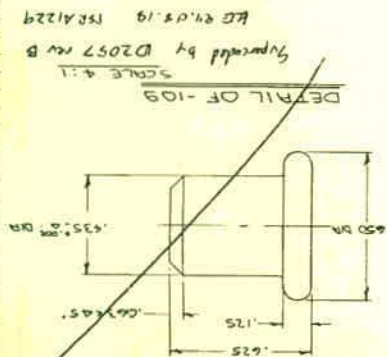
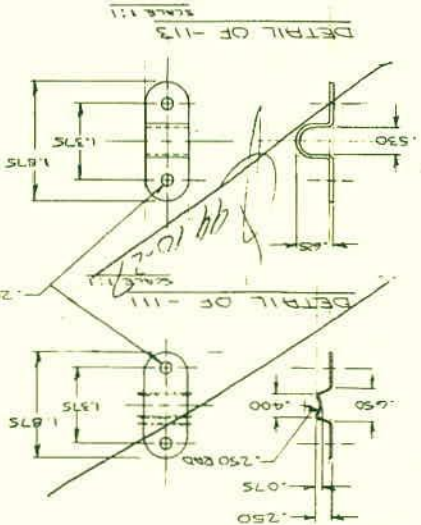
✓	2010-101	BACKSET	2024-13	06-11-13	06-11-13
✗	2010-103	ARM	CRS TUBA 300x105x	MSI 304	06-11-13
1	2010-109	PLUG	606-1-T6 BAR	06-11-13	06-11-13
	2010-111	SPADLE	.025 THICK	MSI 304	06-11-13
	2010-113	CLAMP	.050 THICK	MSI 304	06-11-13
4	PE-022-EF	FASTENER		PM	06-11-13

1. BEND RADII FOR 2024-T3
0.03 THICK IS 1.88
2. PAINT -101 MATTE BLACK
3. THE 304 STAINLESS STEEL MAY
BE SUBSTITUTED WITH TYPES
303 OR 316
4. 2024-T3 MAY BE SUBSTITUTED
WITH 2024-T3 CLAD (2A-B-124/5)
FINISH: POWDER COAT BLACK SHADE
431; (2) 431 OR 432
FE-0282-EF (QTR4)
INSTALL PER PERM. INSTALLATION
INSTRUCTIONS.

GENERAL NOTES:



4/03/05



RELEASED
07-02-08
-10/1-104 TO
HAVE 0-0-0-8 WALL
08-05-87
UNDER REVIEW

Scale 4:1
Supervised by D2057 rev B
EE 24.03.19 156A1229

